



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-634-041
Job Sheet 168468-E



Part No: D205-634-041

Job Qty: 1 ea

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/15/17

Job Tracking No:

Due Date: 12/8/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: California Department Of Forestry & Fire Protection (CCAL101)

5500 Price Avenue McClellan, CA, 95652 USA ph:(916) 561-3359

Note: DWG REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run hrs Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/17	12/7/17	0.00 0.00	Start Up Skid tubes		
110	CNC Bend Skid tubes	1 pcs	12/7/17	12/7/17	0.00 0.65	CNC Bend Skid tube		
120	Skid tubes	1 pcs	12/7/17	12/7/17	0.00 2.89	Skid tubes		
130	QC	1 pcs	12/7/17	12/7/17	0.00 0.00	QC5		
140	Skid tubes	1 pcs	12/7/17	12/7/17	0.00 2.89	Skid tubes		
150	QC	1 pcs	12/7/17	12/7/17	0.00 0.00	QC10		
160	QC	1 pcs	12/7/17	12/7/17	0.00 0.00	QC5		
170	HandFinish	1 pcs	12/7/17	12/7/17	0.00 1.31	HandFinish2		
180	Powdercoat	1 pcs	12/7/17	12/7/17	0.00 0.34	Powdercoat1		
190	QC	1 pcs	12/7/17	12/7/17	0.00 0.00	QC3		
200	HandFinish	1 pcs	12/8/17	12/8/17	0.00 1.31	HandFinish3		
210	QC	1 pcs	12/8/17	12/8/17	0.00 0.00	QC5		
215	DC	1 pcs	12/8/17	12/8/17	0.00 0.00	DC		
220	Packaging	1 pcs	12/8/17	12/8/17	0.00 0.00	Packaging3		
230	QC21-FG	1 Ea	12/8/17	12/8/17	0.00 0.00	QC21		

Part Op 110 - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe batch# in Descriptions: aft end of tube

120 - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

140 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Deburr 6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr 7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

170 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - START TIME: 11:00 O.T. 3:00 FINISH: 11:30 M138467

200 - 1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates Sikaflex expire date: M138657 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

210 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

Wing walk M138711

Plex 11/15/17 8:14 AM dart.poulin.mario

5032461x1

MCS FEB 05 2018

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

 S032461						Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com									
															
Replacement Skidtube with Standard Wearplates Fits LH or RH															
PART NO: Original Serial #: Revision: Operation: Change No:				D205 - 634 - 041 S032461 Start up Operation CHG006				01/16/18 Job No: 168468-E							
Work Order: Part No.: NCR No.:		Date : Step #:		Description Work Order Deviation		QTY Effective									
DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved		☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab													
Root Cause															
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified				☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due				☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter				☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/D ☐ Inspection Incomp ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes			
OTHER : _____															
Turning Sequence _____															

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2580-1 <i>5012315</i>	1	0	0	0
140-Skidtubes <i>11X 3164078</i>	D2576-3 <i>F151399</i>	1	66	0	0
	D4202-1	20	179	0	0
200-HandFinish <i>9x 5030798</i>	ALS7-1032-130 <i>5007279</i>	50	1,947	0	0
	AN3-5A <i>5013737</i>	2	260	0	0
	AN3C4A <i>5019394</i>	50	1,413	0	0
	D2594-1 <i>5025442</i>	16	290	0	0
	D2594-3 <i>F159710</i>	16	403	0	0
	D2855 <i>F147805</i>	1	92	0	0
	D3564-11 <i>5026403</i>	1	17	0	0
	D3564-13 <i>5024217</i>	1	19	0	0
	D3564-5 <i>F159945-2</i>	1	7	0	0
	D3564-9 <i>5023983</i>	1	12	0	0
	D3566-1	2	19	0	0
	D3566-13 <i>NA</i>	1	16	0	0
	D3566-5	1	27	0	0
	NAS1149C0332R <i>5027570</i>	50	3,444	0	0
	NAS1149D0332J <i>5020606</i>	2	1,868	0	0

Part Specifications

Specifications could not be found.

Plex 11/15/17 8:14 AM dart.poulin.mario

000 071

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																						
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<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> <th colspan="4" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td style="width:10%;">Environment ☐</td> <td style="width:10%;">☐</td> <td style="width:20%;">No Re-verification</td> <td style="width:10%;">☐</td> <td style="width:10%;">Pressure/Forced</td> <td style="width:10%;">☐</td> <td style="width:10%;">Temperature/Cure</td> <td style="width:10%;">☐</td> <td style="width:10%;">Power Loss/Surge</td> <td style="width:10%;">☐</td> <td style="width:10%;">Positioned Wrong</td> </tr> <tr> <td>Design ☐</td> <td>☐</td> <td>Operator</td> <td>☐</td> <td>Bending</td> <td>☐</td> <td>Set-up</td> <td>☐</td> <td>Folio/Program</td> <td>☐</td> <td>Outside Dimensions</td> </tr> <tr> <td>Doc/Data ☐</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> <td>Centre Not Concentric</td> <td>☐</td> <td>BOM/Route</td> <td>☐</td> <td>Grain</td> <td>☐</td> <td>Over/Under tolerance</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>☐</td> <td>Supplier</td> <td>☐</td> <td>Cracks</td> <td>☐</td> <td>Broken/Damage/Defect</td> <td>☐</td> <td>Weld</td> <td>☐</td> <td>Part Incorrect</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>☐</td> <td>Training</td> <td>☐</td> <td>Crimp/Kink/Ripple/Wave</td> <td>☐</td> <td>Inspection Incomplete/Unqualified</td> <td>☐</td> <td>Wrong Stock Pulled</td> <td>☐</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Material ☐</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> <td>Cuffs</td> <td>☐</td> <td>Contamination</td> <td>☐</td> <td>Out of Sequence</td> <td>☐</td> <td>Part Moved</td> </tr> <tr> <td>Internal Transport ☐</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td>☐</td> <td>Countersink</td> <td>☐</td> <td>Off-set</td> <td>☐</td> <td>Drawing</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td>☐</td> <td>Cut Too Short</td> <td>☐</td> <td>Mislabeled</td> <td>☐</td> <td>Finish</td> </tr> <tr> <td>LOA ☐</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td>☐</td> <td>Instructions Incomplete/Unclear</td> <td>☐</td> <td>Fit/Function</td> <td>☐</td> <td>Misread</td> </tr> <tr> <td>Substation ☐</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td>☐</td> <td>Drill Holes</td> <td>☐</td> <td>Misaligned/off center</td> <td>☐</td> <td>Turning Sequence</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>☐</td> <td>Manufacturing Process</td> <td colspan="8" rowspan="2" style="vertical-align: top;">OTHER : _____</td> </tr> <tr> <td>Misidentified ☐</td> <td>☐</td> <td>Past Due</td> </tr> </tbody> </table>						Root Cause			FAULT CATEGORY				Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____								Misidentified ☐	☐	Past Due
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ITEM	QTY -041	QTY -045	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-048	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2576-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2596	206 WEB
27	1	1	1	1	D2555	AFT CAP
28	1	1			D3564-5	WEARSHOE
29	1	1			D3564-9	WEARSHOE
30	1	1			D3564-11	WEARSHOE
31	1	1			D3564-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D5061-1	FWD WEARPLATE
36				1	D5061-3	AFT WEARPLATE
50	50	50			AL57-1032-130 or AK57-1032-130 or AK54-1032-130 or AELS-1032-130	INSERT
51	50	50			AN3C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN980C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN980JD10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

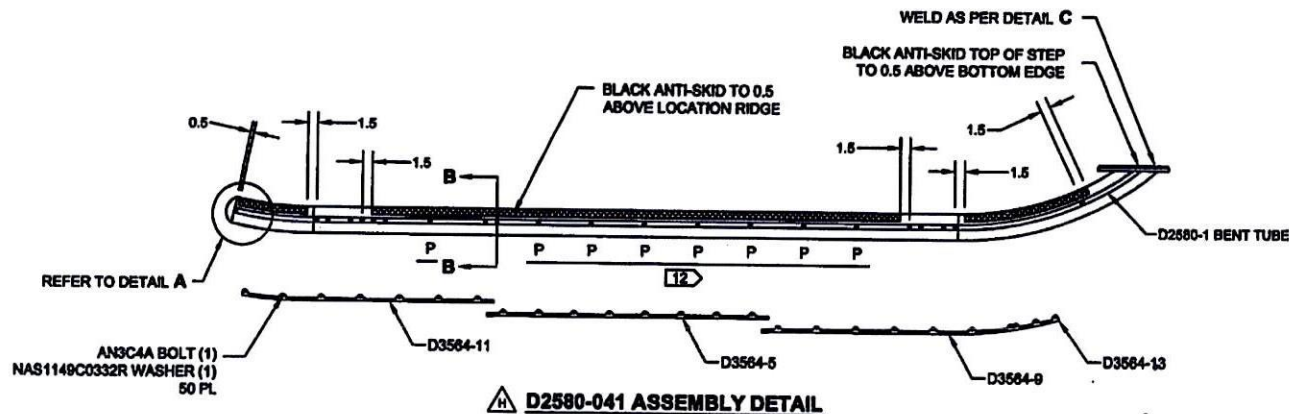
GENERAL NOTES:

- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: NONE
- WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- WELDING PER DART QSI 004.
- INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE DT8217 & DT8837 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2555 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

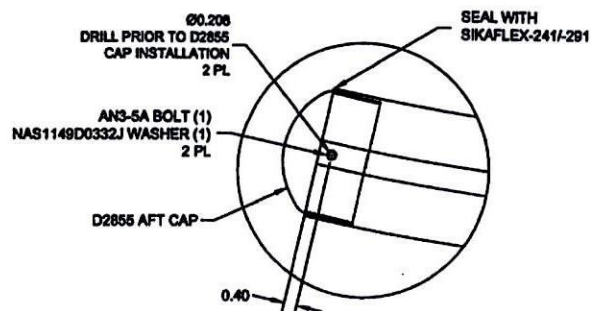
H	SHEET: PL DELETE D3566-1/-5/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9996	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8837 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.06
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	06.06.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	17.06.09		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2580 TITLE 205 SKIDTUBE ASSEMBLY REV. H SHEET 1 OF 9 SCALE NTS COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED

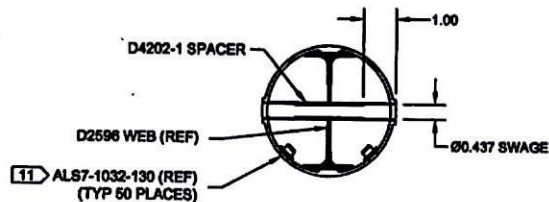
2017 JUL 05
ECON-T-SIG



DETAIL A
SCALE 5X

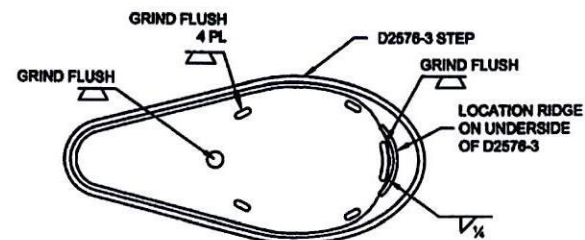


SECTION B-B
SCALE 5X



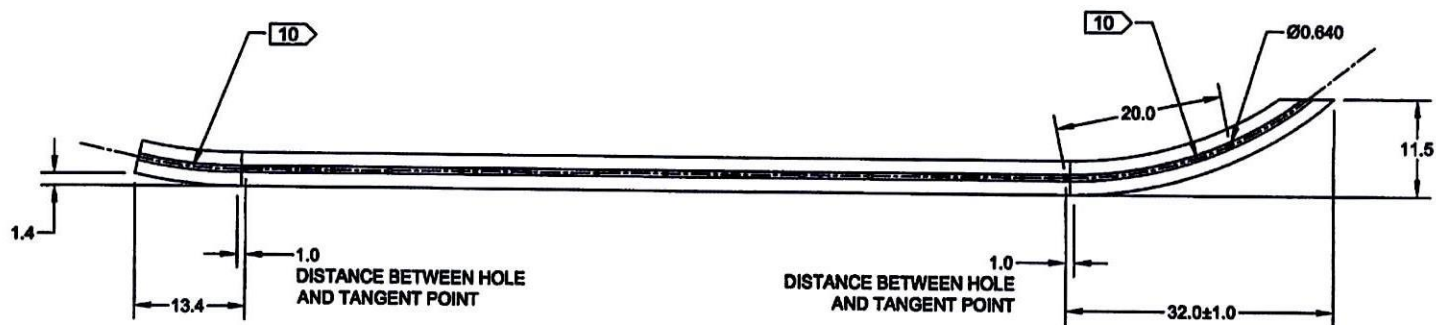
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

DETAIL C
SCALE 5X



RELEASED
2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 2 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
2017 JUL 05 4²

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580	REV. H SHEET 3 OF 9
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

D

C

B

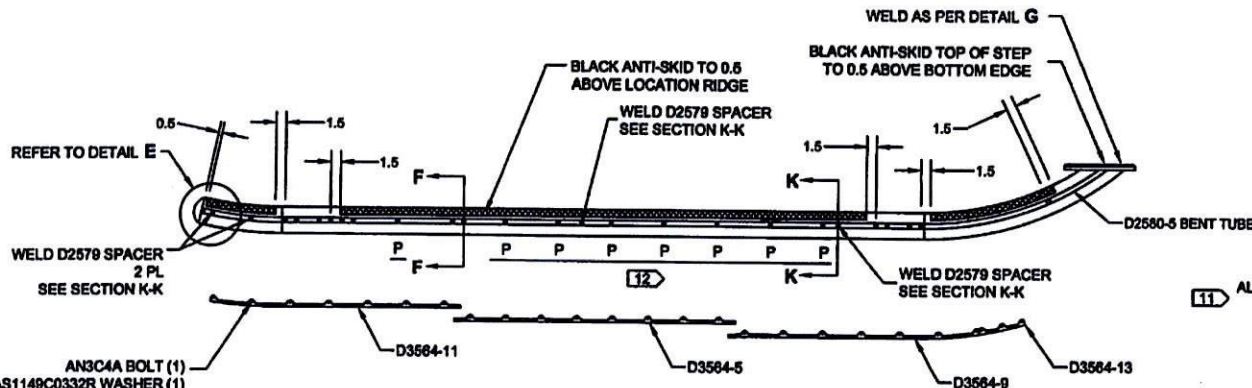
A

D

C

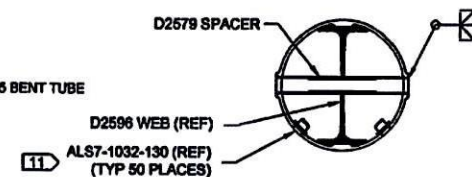
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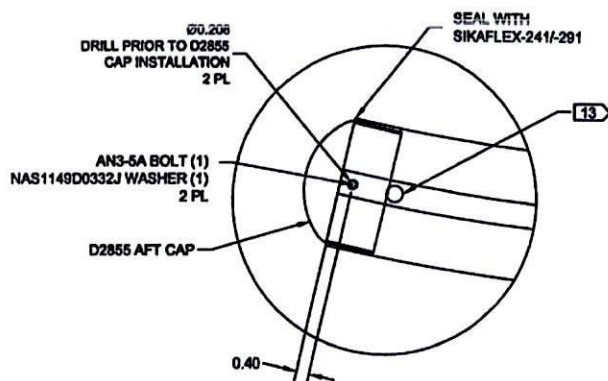
D2580-045 ASSEMBLY DETAIL

SECTION K-K
SCALE 5X



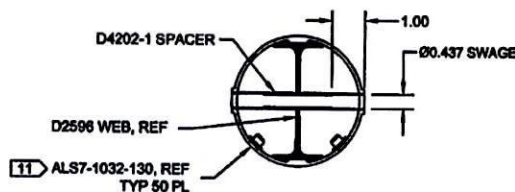
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT CBORE

DETAIL E
SCALE 5X



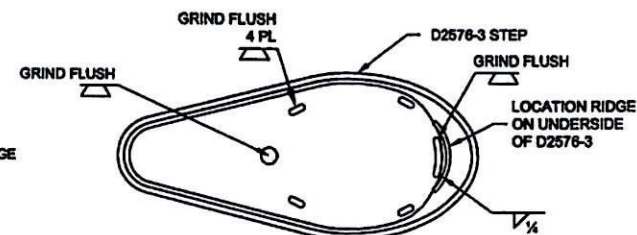
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2017 JUL 05

SECTION F-F
SCALE 5X



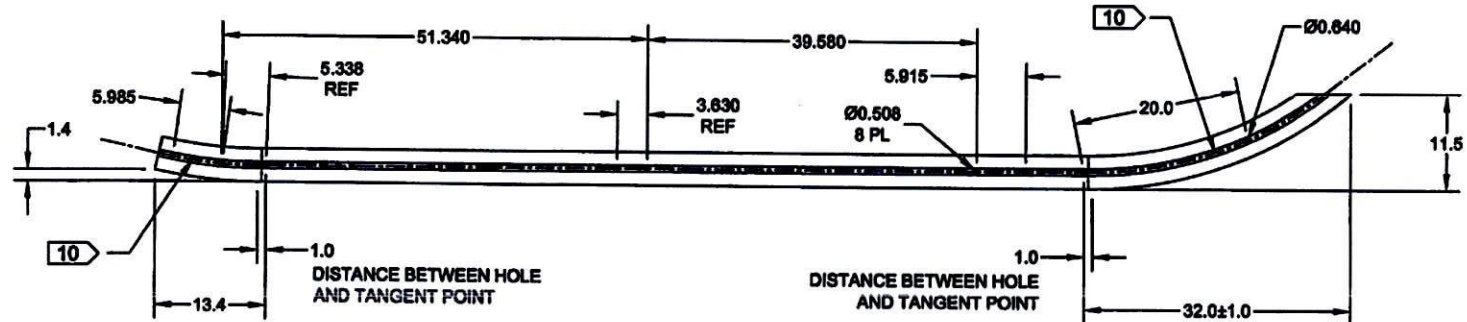
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

DETAIL G
SCALE 5X



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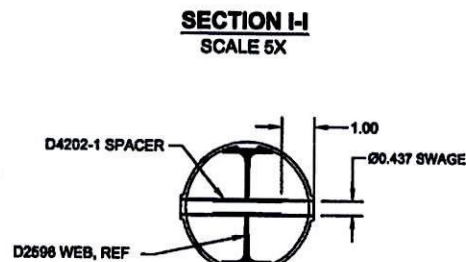
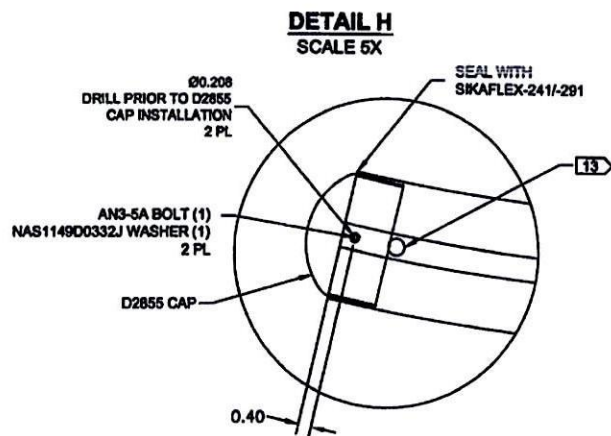
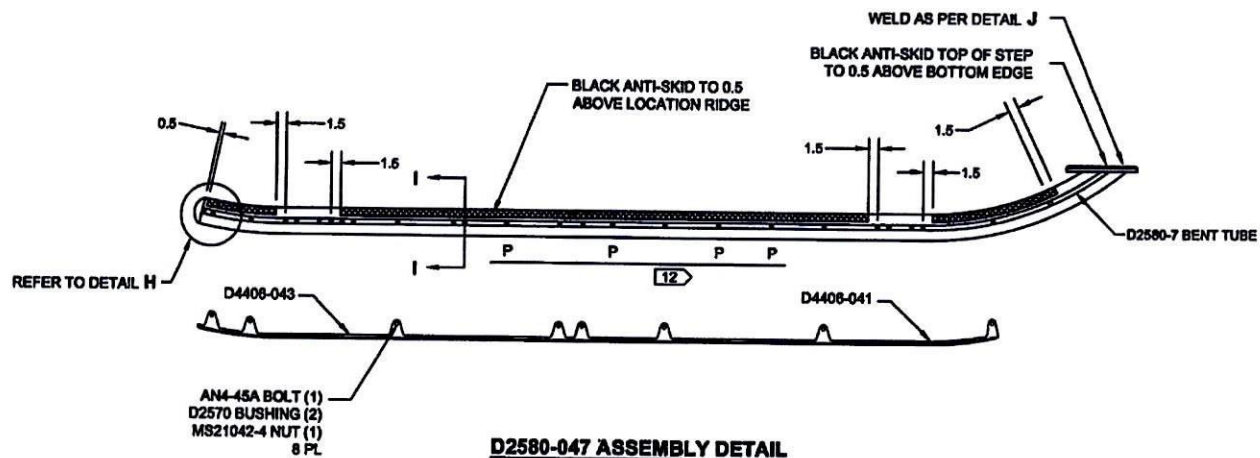


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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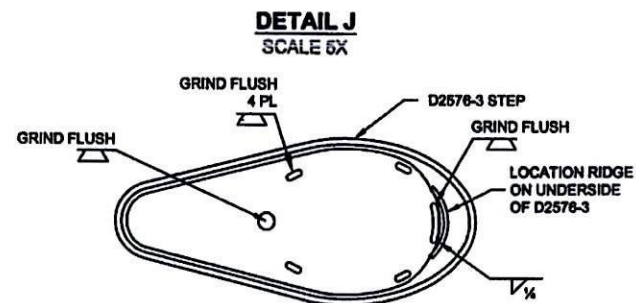
2017 JUL 05 *af*

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
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AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

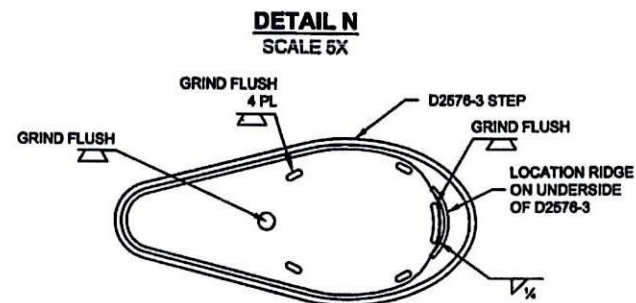
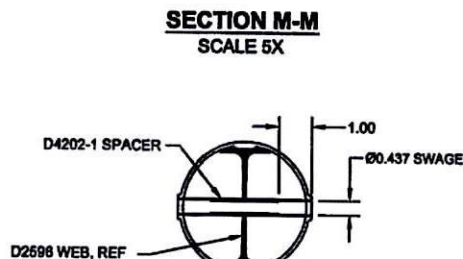
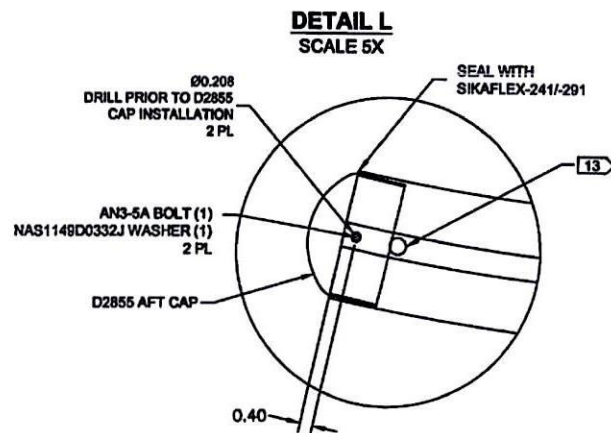
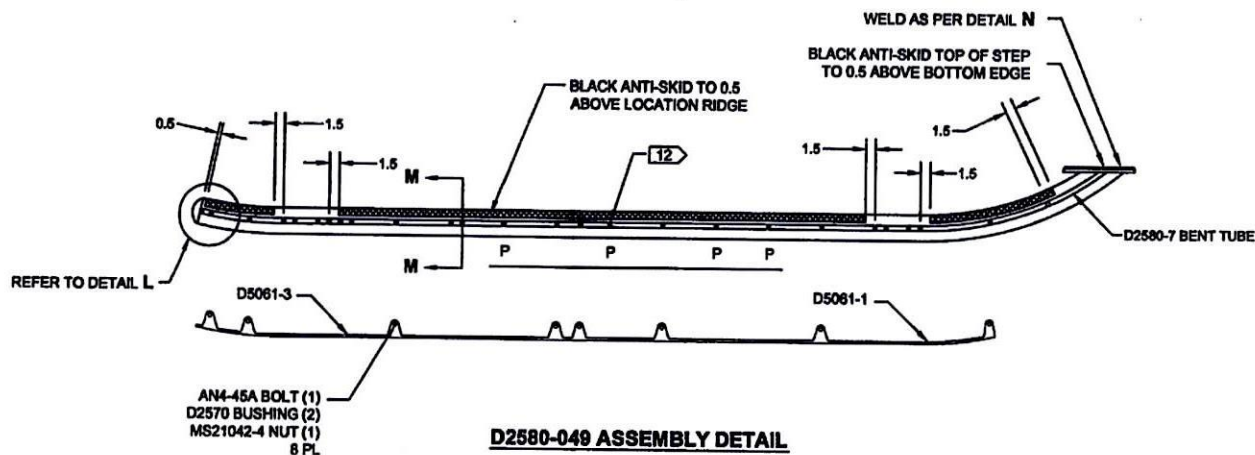
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 8 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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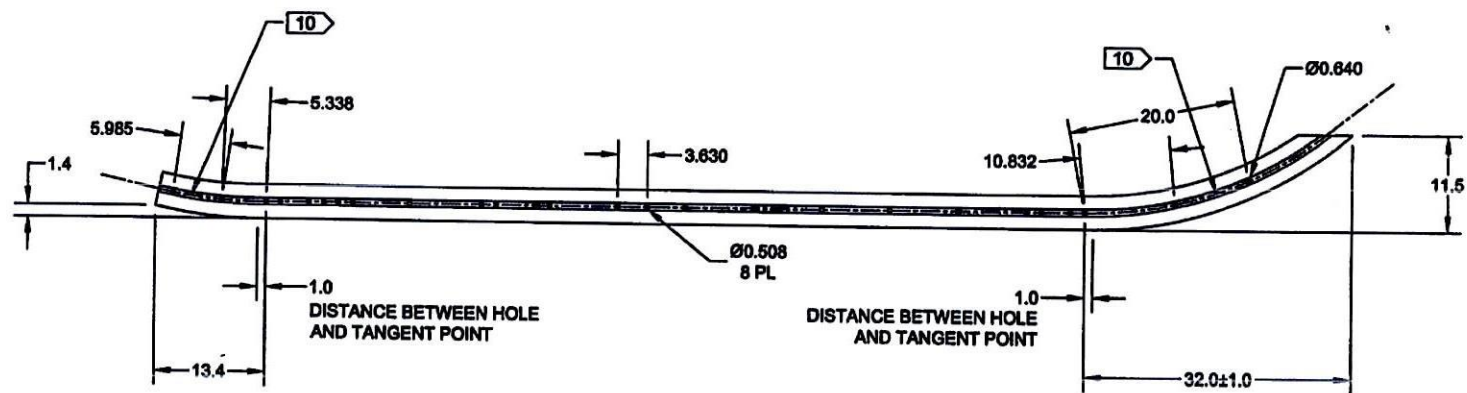
2017 JUL 05



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

RELEASED
2017 JUL 05 *up*

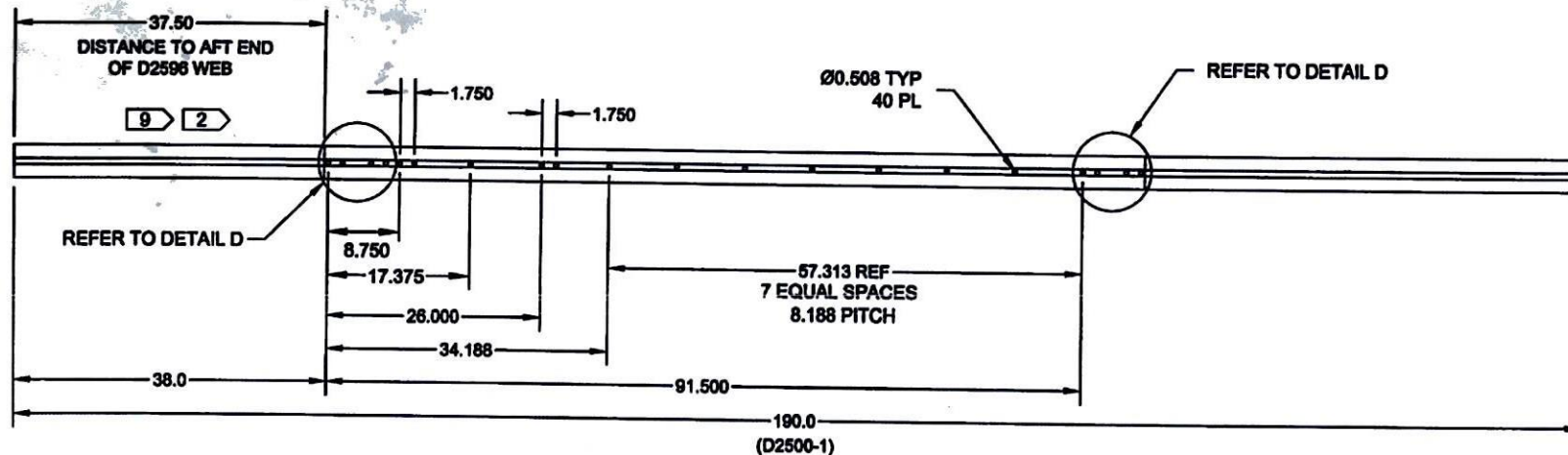
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 7 OF 9
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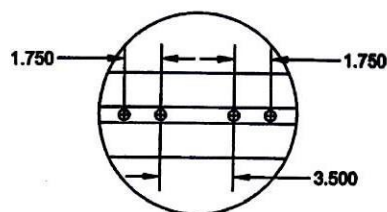
D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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D2580-101 TUBE



DETAIL D
SCALE 5X

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